

# Work Order ID 56880

March 12, 2010 9:57:36 AM



Page 1

Item ID: D3704-3

Accept



Setup Start



Revision ID:

Item Name: Escutcheon

Stop



Start Date: 3/12/10 Start Qty: 6.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 6.00



Customer:

Reference:

*Ref 10-03-12*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT 3.00" LONG

*DIP 10/03/22 6 0*

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA807

DWG REV: B  
FOLIO REV: AA

DEBURR

*DIP 10/03/22*

*MVE 10/03/23*

*6 2*

*PTO*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3704-3 PAR #: \_\_\_\_\_ Fault Category: machining NCR: Yes No DQA: \_\_\_\_\_ Date: 10/03/30  
 Resolution: Scrap Disposition: scrap QA: N/C Closed: \_\_\_\_\_ Date: 10/03/31

NCR: <u>56880</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/22	100	Step 100 on W/O Say's to cut blank at 3.00" long Need to be 3.25" as on folio	<i>[Signature]</i>	Scrap 1 part Change Route to 3.250 R.C.: I.P.P.	DJP 10/03/22 10/03/30	<i>[Signature]</i> 10/03/30	<i>[Signature]</i> 10/03/30	<i>[Signature]</i> 10/03/30
10/03/22	110	Had wrong End Mill in T11 R.C.: L.O.S.	<i>[Signature]</i>	Scrap 1 part	DJP 10/03/22	<i>[Signature]</i> 10/03/30	<i>[Signature]</i> 10/03/30	<i>[Signature]</i> 10/03/30

NOTE: Date & initial all entries

# Work Order ID 56880

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Page 2

Item ID: D3704-3

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Setup Start



Revision ID:

Item Name: Escutcheon

Stop



Start Date: 3/12/10 Start Qty: 6.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

DTP MWF  
10/03/23

6 2

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Jim 10/03/23

B 2

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

el 10/03/24

XB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56880

March 12, 2010 9:57:37 AM



Page 3

Item ID: D3704-3

Accept



Setup Start



Revision ID:

Item Name: Escutcheon

Stop



Start Date: 3/12/10

Start Qty: 6.00



Cust Item ID:

Required Date: 3/19/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*Ind 10/03/24 6*

160

Identify as per dwg & Stock Location: *089*

0.00



Packaging

Memo

0.00

Packaging

*10/03/24 6*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/03/24*

*1210-3-24 6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 12, 2010 9:57:35 AM

Page 1

Work Order ID: 56880

Parent Item: D3704-3

Parent Item Name: Escutcheon

Comments:

Start Date: 3/12/10

Required Date: 3/19/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No				f	52.8210	1.5600			



6061-T6 Bar 1.50 x 1.25



Warehouse                      Loc Qty                      Loc Code

Location

Main Warehouse

MAT

52.8209921

107461

11.84

110936

40.9809921

1.5600

DJP 10/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Escutcheon		<b>Part Number:</b>	D3704-3
<b>Inspection Dwg:</b> D3704	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ X

☐

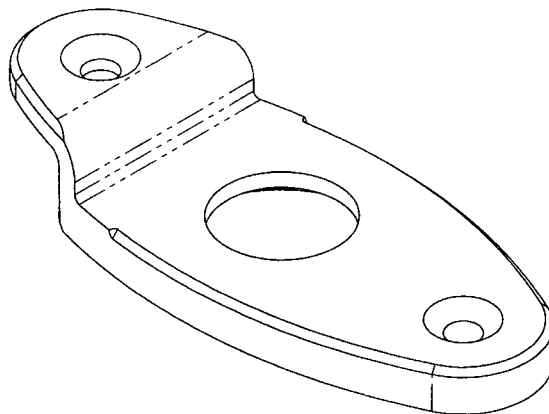
Drawing Dimension		Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.22	+/-0.030	1.222	✓			
0.610	+/-0.010	0.610	✓			
Ø0.170	+0.005/-0.001	0.171	✓			
Ø0.322 x 100°	+/-0.010 x +/-0.5°	0.330 x 100°	✓			
1.063	+/-0.010	1.063	✓			
2.125	+/-0.010	2.125	✓			
1.054	+/-0.010	1.053	✓			
0.206	+/-0.010	0.206	✓			
Ø0.440	+0.005/-0.001	0.441	✓			
0.90	+/-0.030	0.907	✓			
0.500	+/-0.010	0.510	✓			
0.125	+/-0.010	0.130	✓			
R0.06	+/-0.030	0.06	✓			
0.625	+/-0.010	0.625	✓			
R0.156	+/-0.010	0.156	✓			
R0.03	+/-0.030	0.030	✓			
0.03 x 45°	+/-0.030 x +/-0.5°	0.03 x 45°	✓			
Ø0.755	0.005/-0.001	0.755	✓			
0.175	+/-0.010	0.175	✓			
0.218	+/-0.010	0.218	✓			
0.435	+/-0.010	0.436	✓			
0.220	+/-0.010	0.220	✓			
0.06 x 45°	+/-0.030 x +/-0.5°	0.065 x 45°	✓			
Ø0.686	0.008/-0.001	0.685	✓			
Ø0.628	0.008/-0.001	0.628	✓			
0.685	+/-0.010	0.685	✓			

<b>Measured by:</b>	<i>[Signature]</i>
<b>Date:</b>	10/03/22

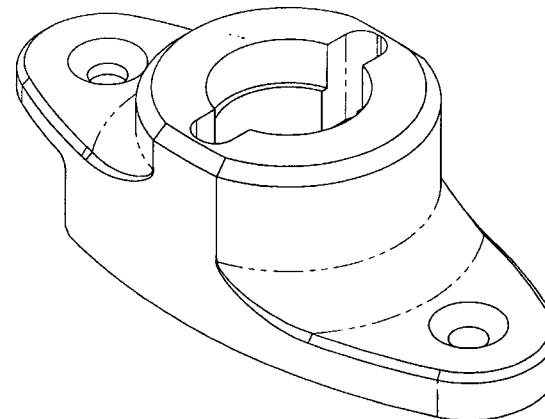
<b>Audited by:</b>	<i>[Signature]</i>
<b>Date:</b>	10-03-24

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ	<i>[Signature]</i>



**D3704-1 ESCUTCHEON**



**B D3704-3 ESCUTCHEON**

56880

RELEASED  
07/04/09

**NOTES:**

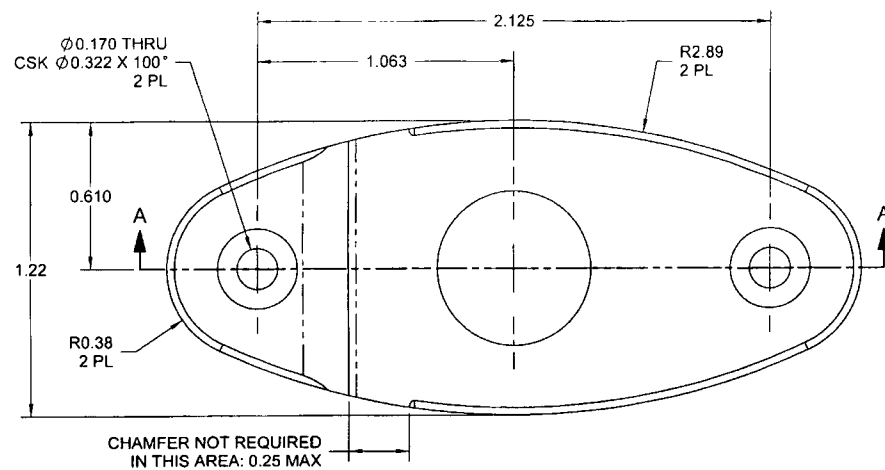
- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
  - D3704-1 = 0.04 lbs
  - D3704-3 = 0.11 lbs

B	ADDED D3704-3. REASON: COMPATIBILITY WITH AA1'S HANDLE	MB	09.03.17
A	NEW ISSUE	MB	08.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.17		

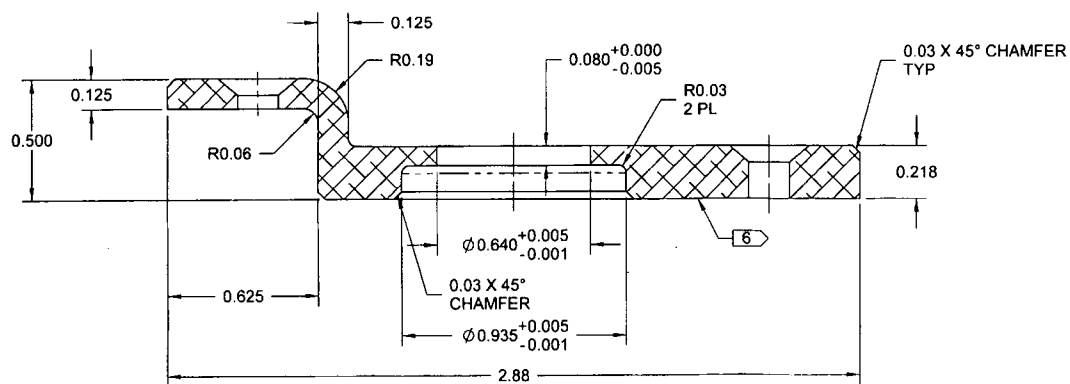
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3704** REV. B  
SHEET 1 OF 3  
TITLE **ESCUTCHEON** SCALE NTS

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**D3704-1 ESCUTCHEON**

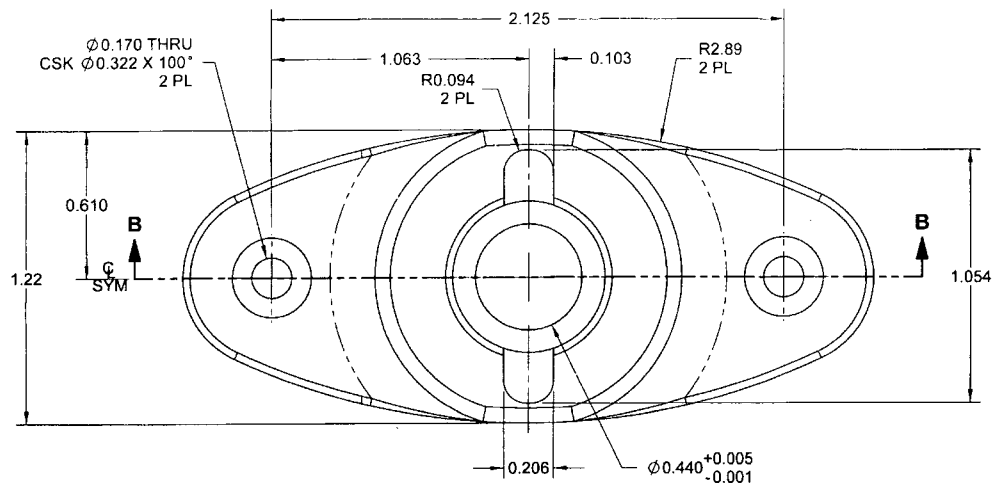


**SECTION A-A**

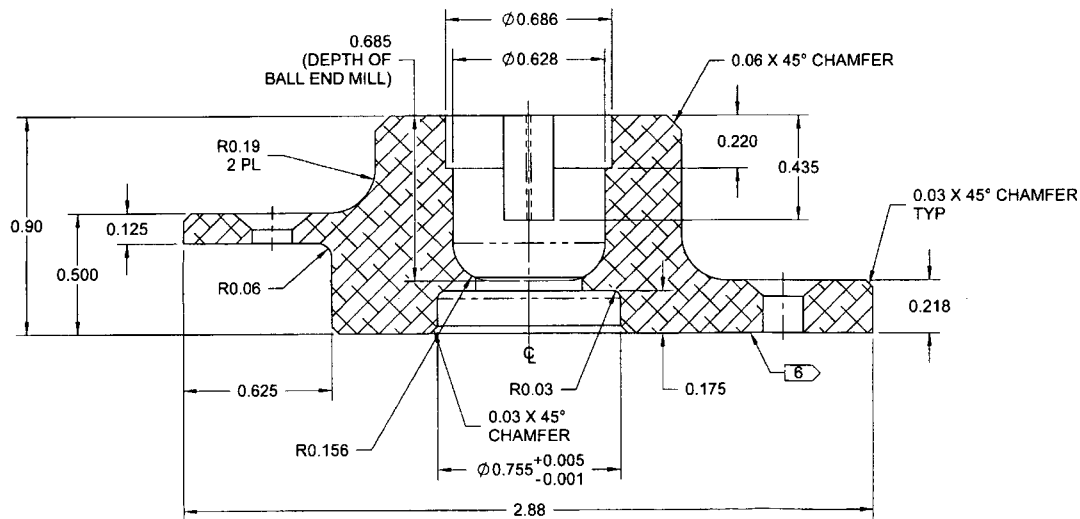
56880

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09/04/09

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3704	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		ESCUTCHEON	SCALE
DE APPR.			NTS
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**D3704-3 ESCUTCHEON**



**SECTION B-B**

56880

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3704	SHEET 3 OF 3
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